

## Page 1

April-27-12 11:20:00 AM

**Reference:**

Stop \*NR2\*

**Insp.  
Stamp**

B

100

0.00

**\*100\***

### Small Fab

## Memo

0.00

## Small Fab

1- Assemble as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

## Memo

0.00

## Quality Control

120

Identify as per dwg & Stock Location:

0.00

**\*120\***

### Packaging

## Memo

0.00

### Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83916

**\*83916\***

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Item ID: D4150-041      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
 Revision ID:      Stop **\*NS2\***  
 Item Name: Attachment Arm Assembly  
 Start Date: 27/04/2012      Start Qty: 5.00      **\*5\***      Cust Item ID:  
 Required Date: 11/05/2012      Req'd Qty: 5.00      **\*5\***      Customer:  
 Reference:

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_      Run Start **\*NR1\***  
 QC: \_\_\_\_\_      Date: \_\_\_\_\_      SPC (Y/N): \_\_\_\_\_      Date: \_\_\_\_\_      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

12/5/10 *[Signature]*

*me*  
12-05-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-27-12 11:20:05 AM

Page 1

Work Order ID: 83916

**\*83916\***

Parent Item: D4150-041

**\*D4150-041\***

Parent Item Name: Attachment Arm Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC  
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C13A <b>*AN3C13A*</b> Bolt		Purchased	No			100	Each	29.0000	2	10			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST351			29					
					117366			1					
					120630			28		10			
D4150-1 <b>*D4150-1*</b> Arm		Manufactured	No			100	Each	20.0000	1	5			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST133			20					
					82912			20		5			
D4150-3 <b>*D4150-3*</b> Arm Plate		Manufactured	No			100	Each	26.0000	2	10			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST133			26					
					81907			6					
					82913			20		10			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-27-12 11:20:05 AM

Page 2

Work Order ID: 83916

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly

**\*83916\***

**\*D4150-041\***

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 5.00

Required Qty: 5.00

MS21043-3

Purchased

No

100

Each

1,097.000

2

10

**\*MS21043-3\***

Nut

\*\*

*SP 12/05/09*

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

124

120693

124

ST301

901

118077

2

118614

83

118686

30

119758

20

121255

766

10

NAS1149C0332R

Purchased

No

100

Each

5,784.000

4

20

**\*NAS1149C0332R\***

Washer

\*\*

*SP 12/05/09*

Location

Loc Qty

Loc Code

ST297

219

119736

196

120648

23

ST298

5565

121255

677

121509

4888

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

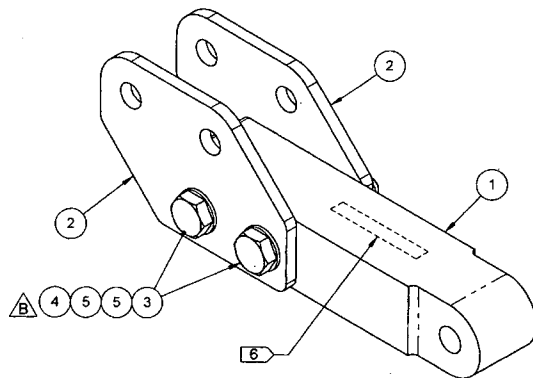
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D4150-041 ATTACHMENT ARM ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.82 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 03916 MLJ  
12/04/27

ITEM	QTY	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER

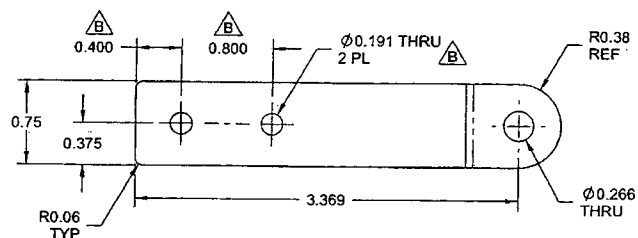
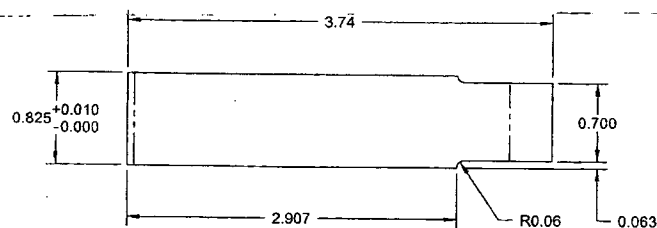
**RELEASED**  
2010-07-16

B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C13A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZIN D3-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZIN C6-2, C7-2, B4-3 & B5-3). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.08
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.08		

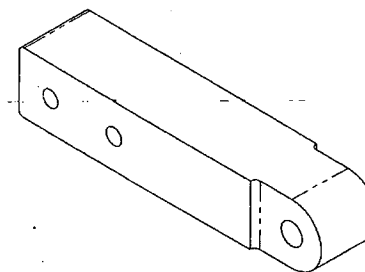
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4150** REV. B  
SHEET 1 OF 3  
TITLE **ATTACHMENT ARM ASSY** SCALE NTS

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**D4150-1 ARM**



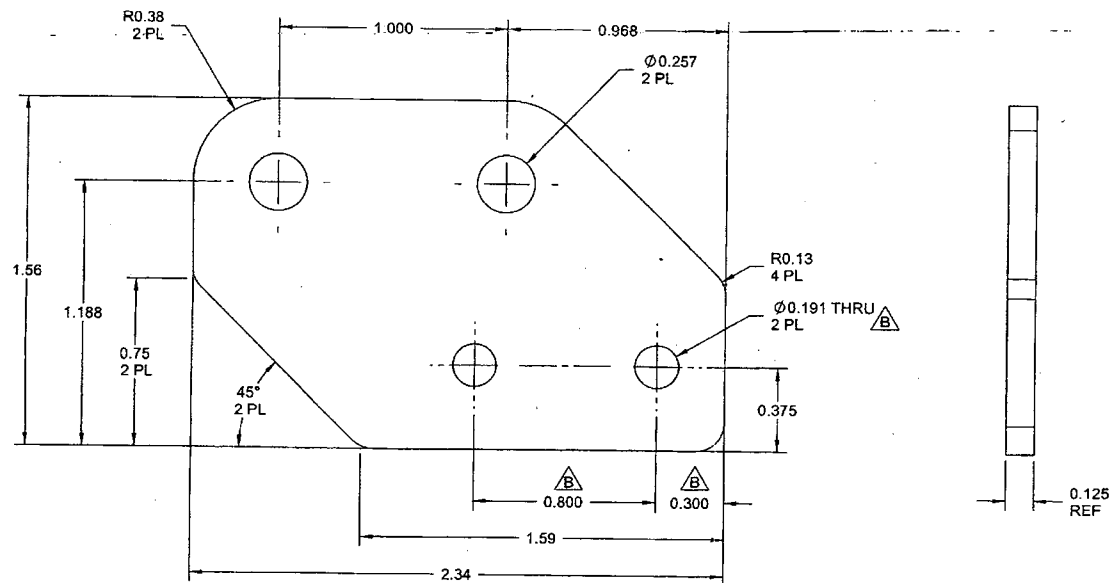
03514

**RELEASED**  
2010-07-16

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4150</b>	REV. B
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		<b>ATTACHMENT ARM ASSY</b>	NTS
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**D4150-3 ARM PLATE**

**RELEASED**  
2010-07-16

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4150</b>	REV. B
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>ATTACHMENT ARM ASSY</b>	NTS
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